Work Order  Vanuary-07-14 3:0	ID 110704 01:07 PM		*110	704*						Page 1
Revision ID:	3535-39 tainless Steel Wearplate Center Aft		Accept	*N900	) <u>0</u> 40	100	<b>)*</b> s	etup Start	171	S1* S2*
Start Date: 1/ Required Date: 1/	/07/14 Start Qty: 6.00	*6* *6*		Cust Item Customer				. هوب	"IVI	
	Process Plan: MP/MLJ	Date: 14-01-09	Tooling: SPC (Y/N):		)ate: )ate:		R	tun Star Stop	<b>''IV</b>	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3535	Rev B									
*1 AA* Waterjet FLOW CNC Waterjet	FLOW WATER JET  Memo  1-Cut as per Deburr if ne	Dwg D3535 Dwg Rev: cessary	0.00 0.00 Prog Rev:	<b>&gt;</b> 2-			6			<u>Im 14-</u> 02-
*110 *110* OC	QC2- Inspect parts off m  Memo	achine FAI/FAIB	0.00	•			<u>(</u>	_6_		<u> In14</u> -02
Quality Control  120  *1 20*	QC8- Inspect parts - seco	and check	0.00 PAS 0.00 14 27				6			
QC	Memo		0.00	' /						

Quality Control

DQA:			Date:			WORK OPPER NON	~	NEO	DAMANICE / LL	DDATE				•	TRAC
QA Closed:			Date:			WORK ORDER NON-	-C(	JNFO	KIVIANCE / U		Wor	k Order up	date only	$\neg$	AEROSPACE
Work Orde	ar:			•		DISPOSITION			•	AGAINST I	DEPA	ARTMENT	PROCESS		
Part f	•					Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.		Engineering Quality
NCR I	No.					Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite	_	Rec/Stor	e/Packaging Supplier		Other
Root					Desci	ription of work order update		Initial		tion		Sign &		$\Box$	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	4	Date	Verification	니	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process						·									
Supplier Training Transport															
Unapproved				<b>.</b>											<u> </u>
							FAI	ULT CA	TEGORY						
Landi	ng (	Gear				General		_		_			_		
		Bending Centre No Cracks	ot Concer	ntric		Bend BOM/Route Broken/Damage/Defect		Folio/F Grain Hardwa	Program		$\Box$ c	Outside Dim Over/Under art Incorrec	tolerance	-	Pressure/Forced Set-up Temperature/Cure
	-	Crimp/Kir	nk/Rinnle	/\ <i>M</i> /ave		Burrs		4	ion Incomplete/U	ngualified	—	art Incorrect art Lost/Mi	<u>+</u>	$\dashv$	Weld
		Cuffs	ny mppic	, wuve		Contamination		4 .	tions Incomplete/	· · · · · · · · · · · · · · · · · · ·	_	art Moved	- <u>-</u>		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		]P	ositioned V			
		Heat Trea	at			Cut Too Short		Mislab	eled		P	ower Loss/	Surge [		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	_					
		Marks/Ch	natter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	е		Fit/Function		Out of	Sequence						

Work Ore January-07-14				*11	N7N4*		Page
Item ID: Revision ID:	D3535-39			Accept	*N900040100*	Setup Start	14.71
Item Name: Start Date:	Stainless Ste	el Wearplate Center Aft  Start Qty: 6.00	*6*		Cust Item ID:	500 <b>F</b>	*NS2*
Required Dat	-, ,	Req'd Qty: 6.00	*6*		Customer:		
Reference: Approvals:	Process P	lan	Date:	Tooling:	Date:	Run Star	*NR1*
Approvais.	QC:		Date:	SPC (Y/N):	Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00			DAS	C			14103
*130*	NC BRAKE				30	6			
Brake NC	Memo	0.00			9-89				
Brake NC	Deburr if necessaryForm on Brake as pe DT8326.Identify as D3535-41Form Jogg Dwg D3535								
		DA!	_						
140	QC5- Inspect part completeness to step on W/O	0.00	•			(			
*1 <i>4</i> 0*		14/2	lu						
QC	Memo	0.00	<i>v</i>						

150

\*150\* Powdercoat

Quality Control

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

FINISH TIME:

0.00

6 6 H-2-5 358

Page 2

DQA:			Date:			WORK OPPER NON	~	NIFOI		DDATE				7	DART
QA Closed:			Date:			WORK ORDER NON-	-((	JNFOI	RIVIANCE / U		Wo	ork Order up	date only	٦	AEROSPACE
Work Orde	٠r.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS	•	
WOIK OIGE	=1.					Rework			Skid-tube	Crosstube			Water Jet	$\neg$	Engineering
Part N	J۸					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	$\dashv$	Quality
	٠٠.					Use-as-is			noforming	Finishing			e/Packaging	$\dashv$	Other
NCR N	No.				<del></del> -	Suspected Unapproved		,,,,	Large Fab	Composite		, , , , , ,	Supplier		
Root					Desc	ription of work order update	ı	nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material						!									
Operator															
Offset/Setup							ļ		1				-		
Process			:												
Supplier		!													
Training															
Transport															
Unapproved				•											
			•	·			FAI	ULT CA	TEGORY						
Landi	ng G	Gear				General									
		Bending				Bend	Π	Folio/F	Program			Outside Dim	ensions	P.	ressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	S	et-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorred	ci	T	emperature/Cure
·		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Inqualified		Part Lost/Mi	ssing	_	Veld
	-	Cuffs				Contamination		1	tions Incomplete/	•		Part Moved		$\exists_{v}$	Vrong Stock Pulled
	$\vdash$	Crushing				Countersink		i .	gned/off center		$\vdash$	Positioned V	∟ Vrong		_
		Heat Trea	it			Cut Too Short		Mislabe				Power Loss/		По	ther-
		Inspection		Tube		Drawing		Misrea					~ L.		
		Marks/Ch	-			Drill Holes		Off-set							
	$\vdash$	Turning S				Finish	$\vdash$	4	Calibration						
	H	Wave/Tw	-		<b> </b>	Fit/Function	-	4	Seguence						

Work Orde January-07-14		0704		*110	704*						Page
Item ID: Revision ID: Item Name:	D3535-39 Stainless Stee	l Wearplate Center Aft		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	1/07/14 1/07/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					
Approvals:	Process Pla	an:	Date:	Tooling: _	Da	nte:			Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*NR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Insp. Number Stamp
160		QC3- Inspect Part Finish		0.00							DAS
*1 60*		Memo		0.00					ШDE	2-05	_ 9 9-89
Quality Control											
170		Identify as per dwg & Stoo	ck Location: FP-D	07 0.00						<i>(</i>	816 )
*170* Packaging		Memo		0.00				x 6		4	YK 14/0

180

Packaging

QC21- Final Inspection - Work Order Release

0.00

\*1 20\*

Memo

0.00

Quality Control

MLJ 14-02-05

DQA:			Date:												TOAR
						WORK ORDER NON-	-CC	ONFO	RMANCE / UI				_		AEROSPACE
QA Closed:			Date:							\	Nork (	Order u	pdate only		
Work Orde	er:					DISPOSITION				AGAINST [	PEPAR	TMENT	/PROCESS		
1	•					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	1	Prc	d. Eng. Coor.		Quality
	•					Use-as-is		Therr	noforming	Finishing	1	Rec/Sto	re/Packaging		Other
NCR N	ю.		<del></del>			Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		nitial	Act	ion	S	ign &		-	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	n	QC Inspector
Design															
Doc/Data									}					ļ	
Equip/Tooling	_														
Handling/Pre													1		
Material															
Operator															
Offset/Setup											-				
Process															:
Supplier		:					'								
Training															
Transport				Ì											
Unapproved			1		<u> </u>		EAL	III T CA	TEGORY				1	_	
Landi	oa G	Goar				General	FA	OLI CA	TEGORT					—	
Landi		Bending				Bend		] Folio/F	Program	ſ	ارم	tside Din	nensions	$\Box$	Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route	H	Grain	10614111	F			r tolerance	Г	Set-up
		Cracks				Broken/Damage/Defect	<u> </u>	Hardwa	are .	ŀ	— 1	t Incorre		Г	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		4	ion Incomplete/Ur	ngualified	<b>⊣</b>	t Lost/M	i		Weld
	_	Cuffs		•		Contamination		4	tions Incomplete/l	-	-	t Moved	_	_	Wrong Stock Pulled
	-	Crushing				Countersink	T	4	gned/off center			sitioned \			, -
		Heat Trea	it			Cut Too Short		Mislab	-		_	wer Loss,	_	Γ	Other
		Inspection	n Strip in	Tube		Drawing	Г	Misrea	d ·	_					
		Marks/Ch	atter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence						

January-07-14 3:01:07 PM

Page 1

Work Order ID:

110704

Parent Item:

D3535-39

**Parent Item Name:** 

Stainless Steel Wearplate Center Aft

**Start Date:** 1/07/14

Required Date: 1/07/14

Start Qty: 6.00

Loc Code

Required Qty: 6.00

**Comments:** 

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

	III Kev.D As pe	1 KCV B 07-08-3	1 JLM	Verifica Dy.E										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304S20GA		Purchased	No			100	sf	298.5500	0.951	6.0063156	1	e id.	3/3	
304/316 .040 Sheet											<u> </u>	<u> </u>	<u>-01.</u> 5	(

 Location
 Loc Oty

 MAT020
 298.55

 m126852
 7.75

 m127454
 290.8

127454 ->

DQA:			Date:												
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UF	PDATE					AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEI	PARTMENT	/PROCESS		
	-					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	-					Use-as-is			noforming	Finishing			e/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update	ı	nitial	Acti	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	4	QC Inspector
Design														1	
Doc/Data													•		
Equip/Tooling	Ш													Ì	
Handling/Pre															
Material															
Operator	Щ		 												
Offset/Setup					ļ										
Process									ļ						
Supplier					l										
Training															
Transport	Щ													Í	
Unapproved	l							=				<u> </u>			
<u> </u>							FA	ULI CA	TEGORY						
Landi						General		1	<b></b>	1		المستعد منا	: Г	$\neg$	Dunnan /Famand
	$\vdash$	Bending			-	Bend BOM/Route	$\vdash$	4 .	Program			Outside Dim		⊣	Pressure/Forced
	-	Centre No	ot Concer	itric	-	BOM/Route Broken/Damage/Defect	$\vdash$	Grain				Over/Under			Set-up
,		Cracks Crimp/Kir	ak/Binnla	Maria	-	<b>.</b>	$\vdash$	Hardwa	ire ion Incomplete/Un	avalified		Part Incorre Part Lost/M	<u> </u>	-	Temperature/Cure Weld
		Cuffs	ik/ Kippie,	/ vv ave	$\vdash$	Burrs Contamination	-	1	•	•	_	Part Moved	, , , , , , , , , , , , , , , , , , ,		Wrong Stock Pulled
	$\vdash$	Crushing				Countersink	$\vdash$	4	tions Incomplete/U gned/off center	ricieat	┝	Positioned V	L Vrong	لــ	Wrong Stock Fulled
,	Н	Heat Trea	<b>.</b> +		-	Cut Too Short	$\vdash$	Mislab				Power Loss/		$\neg$	Other
	$\vdash$	Inspection		Tube	-	Drawing		Misrea			<u> </u>	], 04401 5033/	-wi6c [		
	-	Marks/Ch	•	·ubc	-	Drill Holes	$\vdash$	Off-set							
1	$\vdash$	Turning S				Finish		4	Calibration						
		Wave/Tw			<b> </b>	Fit/Function		4	Sequence						

DART AEROSPACE LTD	Work Order:	110704
Description: Wearshoe	Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

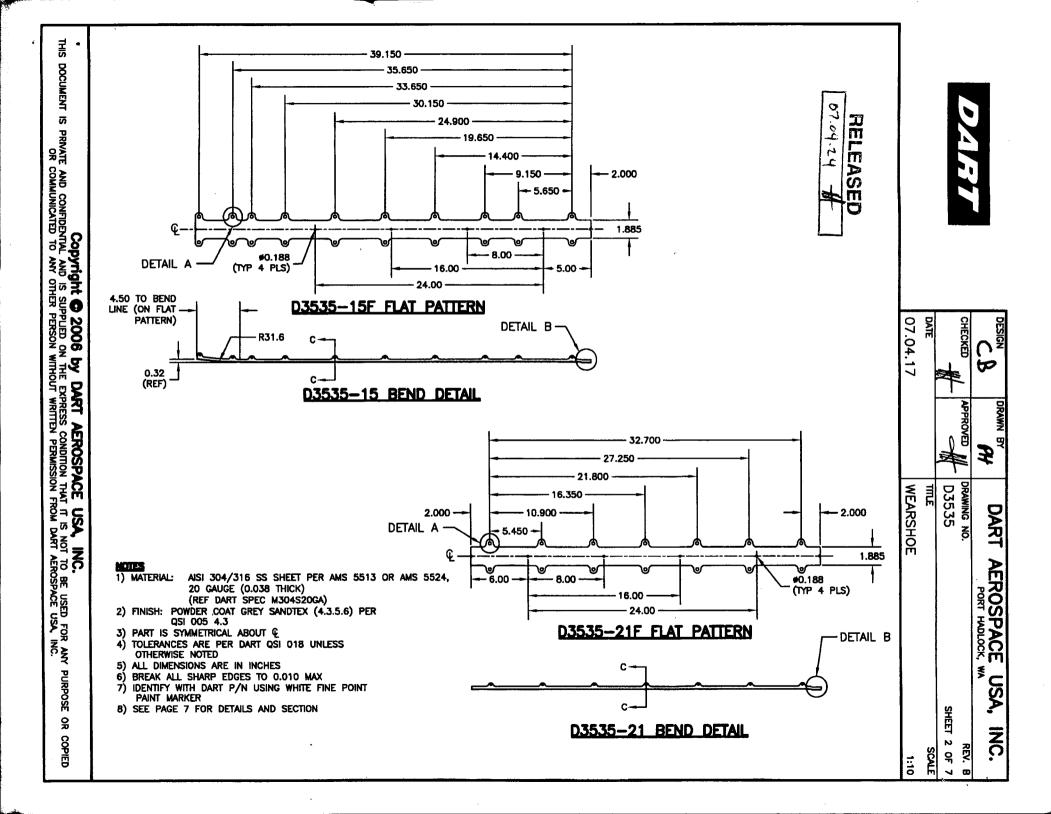
X First Article	Prototype
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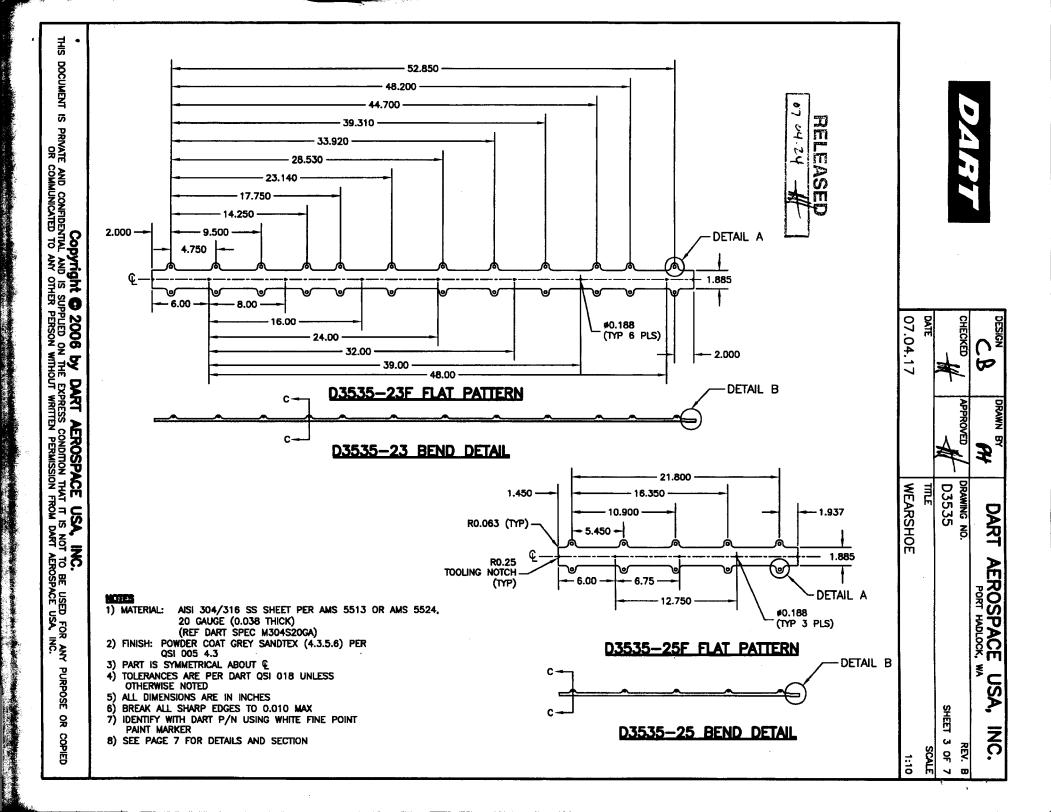
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.85	_		T	Jamole
32.775	+/-0.010	32.775			て	
29.275	+/-0.010	29.275	_		T	
25.775	+/-0.010	25.775	_		т	
23.250	+/-0.010	23.250	-		T	
19.750	+/-0.010	19.750"	_		T	
17.750	+/-0.010	H.750°			Τ	
14.250	+/-0.010	14.250	_		丁	
9.500	+/-0.010	9.506			V	Jamos
4.750	+/-0.010	4.753	_		V	
2.000	+/-0.010	2000	-		V	
5.00	+/-0.030	6.003"	-		V	
9.00	+/-0.030	9.005			V	
28.00	+/-0.030	28.00°	_		1	
Ø0.188	+0.005/-0.001	0.190	_		V	
1.885	+/-0.010	1.889"	_		V	
0.300	+/-0.010	0.303	_		V	
0.300	+/-0.010	0.302		-	V	
0.038	+/-0.010	0,038	-		V	

		OAS					
Measured by:	Tm	Audited by:		27	Proto	type Approval:	N/A
Date:	14-02-1	Date:	14	23		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue	KJ/JLM	E

4.4





DATE

CHECKED

APPROVED

D3535 DRAWING NO. B

B

DART

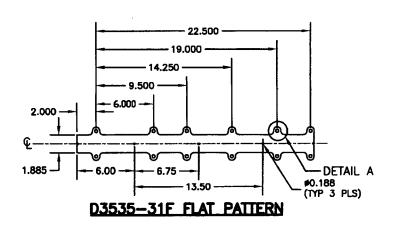
**AEROSPACE** 

07.04.17

WEARSHOE

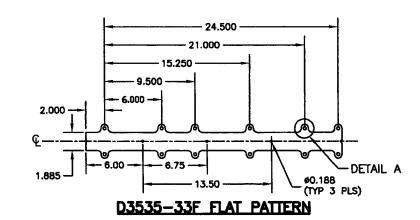








D3535-31 BEND DETAIL



1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3

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DOCUMENT

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3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

c			
c	533 RENI	D DETAIL	

07.04.17

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B

DART

AEROSPACE PORT HADLOCK,

₹ C.

D3535 DRAWING NO.

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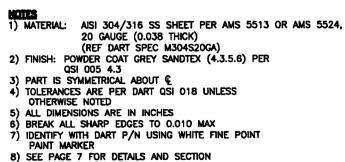
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23,250 19.750

#0.188 (TYP 2 PLS)

17.750

D3535-35F FLAT PATTERN

D3535-35 BEND DETAIL

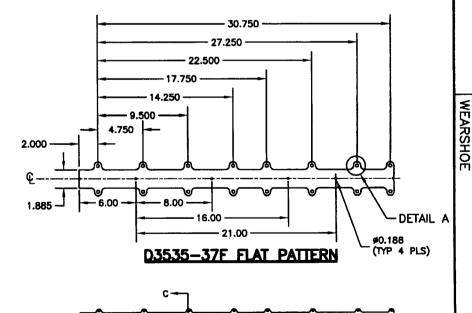
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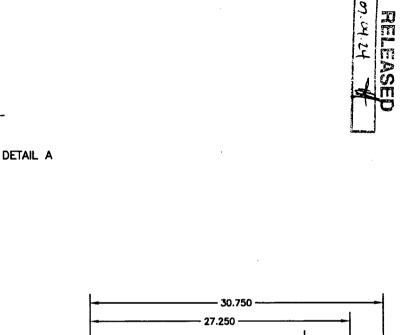
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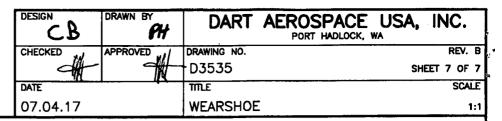
8) SEE PAGE 7 FOR DETAILS AND SECTION

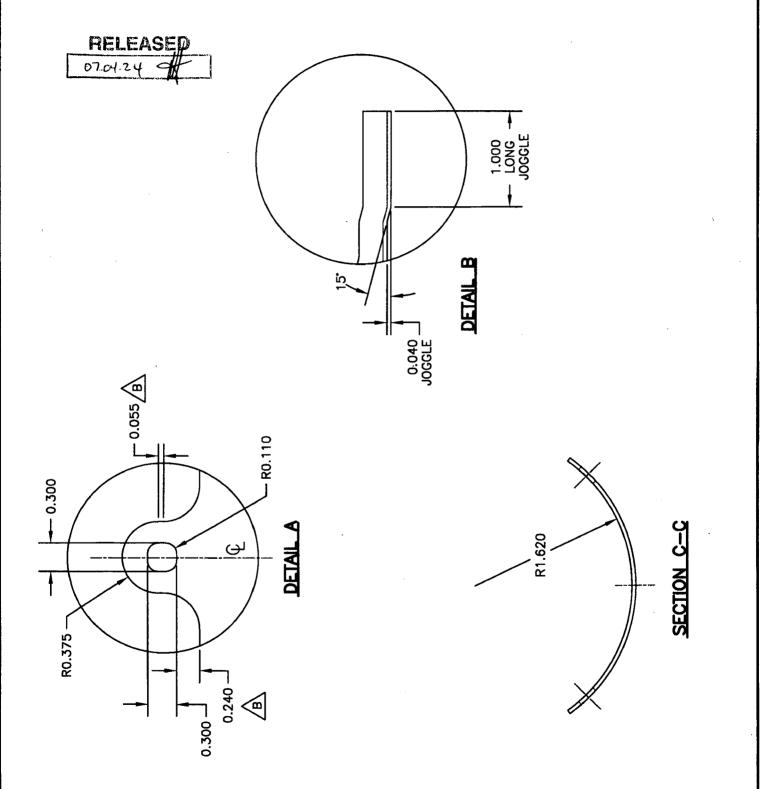


D3535-37 BEND DETAIL









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